

Date: Wednesday, 3/26/2008 9:54:22 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 38183	
Estimate Number : 12716	
P.O. Number :	Part Number : D353635
This Issue : 3/26/2008 S.O. No. :	Drawing Number : D3536 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 37352	Material :
Written By :	Due Date : 4/4/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JD 08-3-27</u>	
Comment : Est Rev:A New Issue 07-02-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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7.



Comment: Qty.: 0.6507 sf(s)/Unit Total : 13.0137 sf(s)

NEOPRENE SHEET 0.063

Batch: 106614 IB 8-3-31

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: A

Prog Rev: A

IB 8-3-31

(26)

2-Deburr if necessary 1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 8-3-31



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

8 08/03/08 (26) counter

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 7-15406 (26)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:54:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 38183

Part Number: D353635

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/03 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion:



mf

08-03-31

W

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38183
Description: Gasket		Part Number: D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.25	*			
19.75	+/-0.030	19.75	*			
17.75	+/-0.030	17.75	*			
14.25	+/-0.030	14.25	*			
9.50	+/-0.030	9.50	*			
4.75	+/-0.030	4.75	*			
2.00	+/-0.030	1.98	*			
6.00	+/-0.030	6.00	*			
6.75	+/-0.030	6.75	*			
0.30	+/-0.030	.302	*			
0.30	+/-0.030	.302	*			
1.89	+/-0.030	1.888	*			
Ø0.19	+0.005/-0.001	.193	*			
0.063	+/-0.010	.062	*			

Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 8-3-31	Date: 08/03/31	Date:	N/A

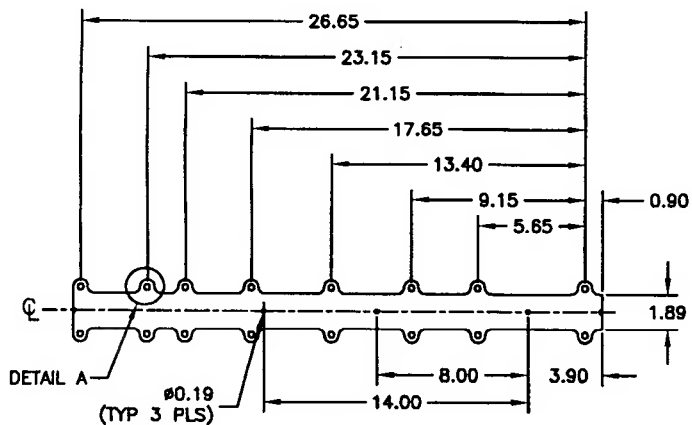
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

DART

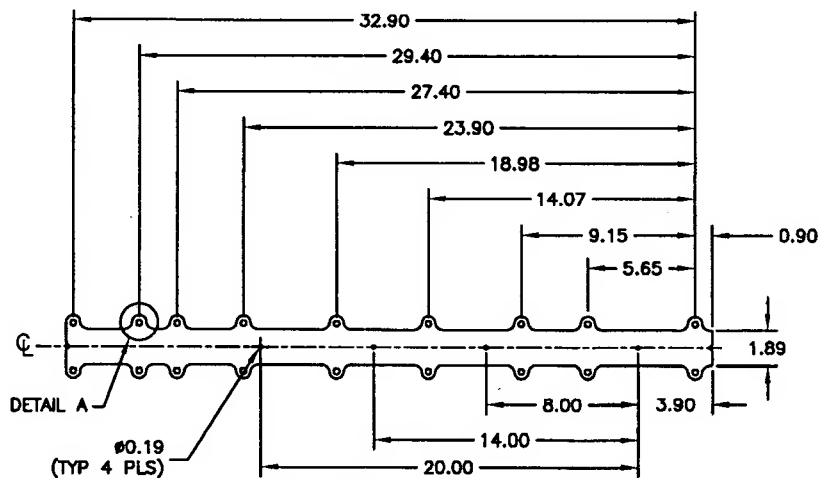
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09.02.12

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 1 OF 8
A	06.10.25	NEW ISSUE		SCALE 1:10



D3536-11 GASKET



D3536-13 GASKET

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WORK ORDER
NO. 38183

NOTES

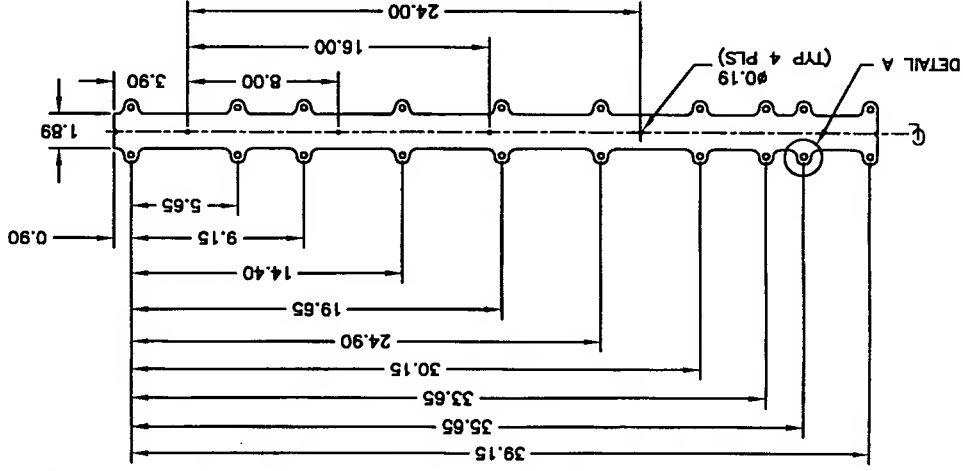
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



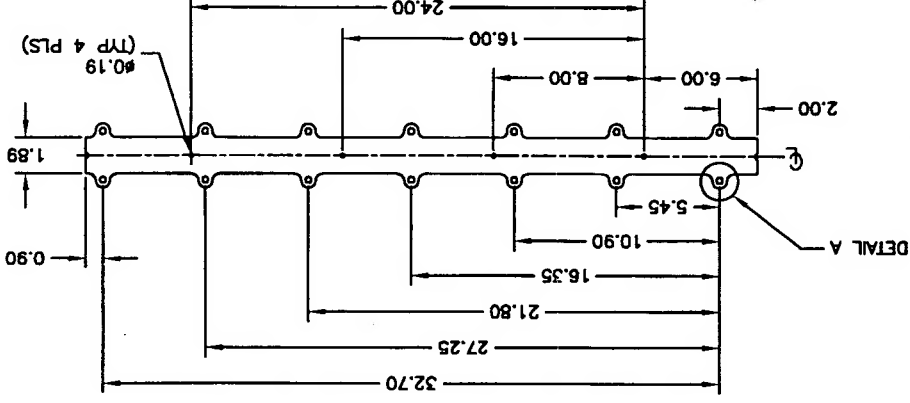
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DATE 06.10.25	TITLE GASKET	SCALE 1:10	

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D3536-15 GASKET



D3536-21 GASKET

- NOTES
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
 - 2) FINISH: NONE
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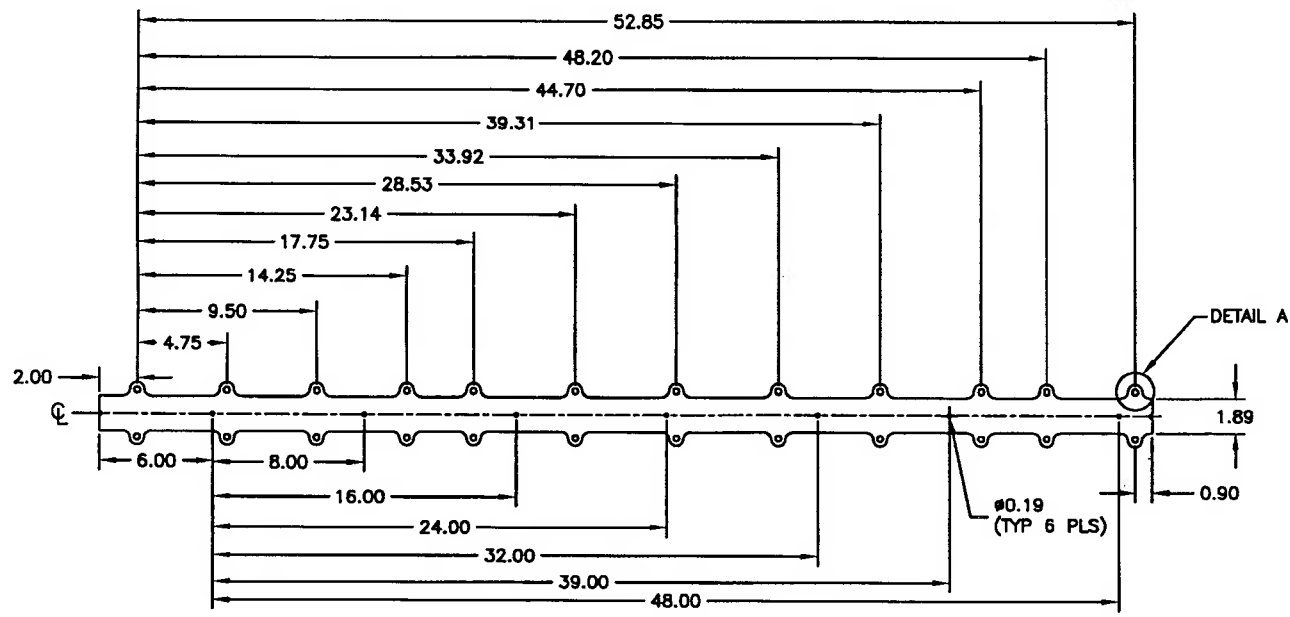
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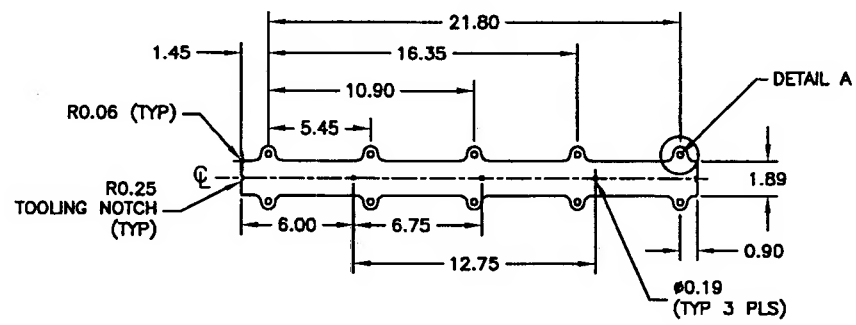
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	



D3536-23 GASKET



D3536-25 GASKET

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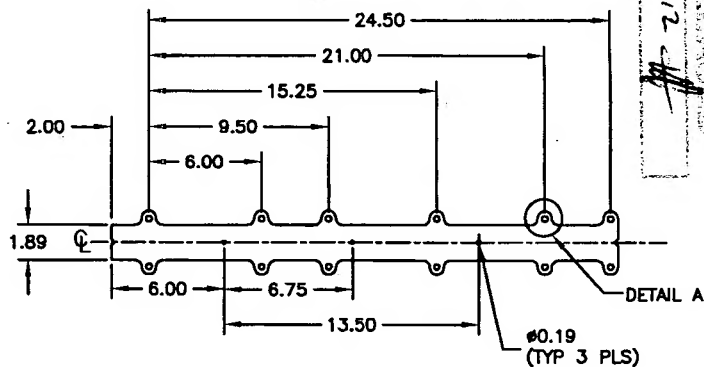
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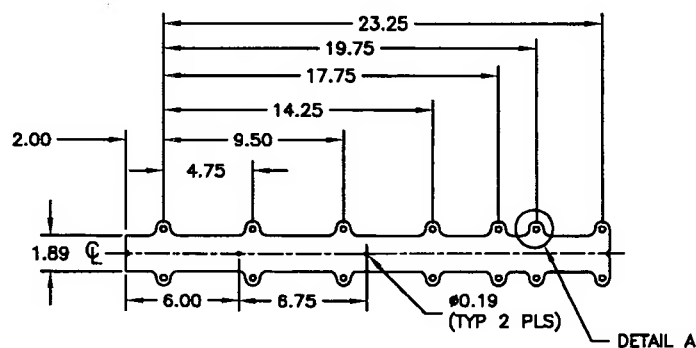
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		SCALE 1:10	

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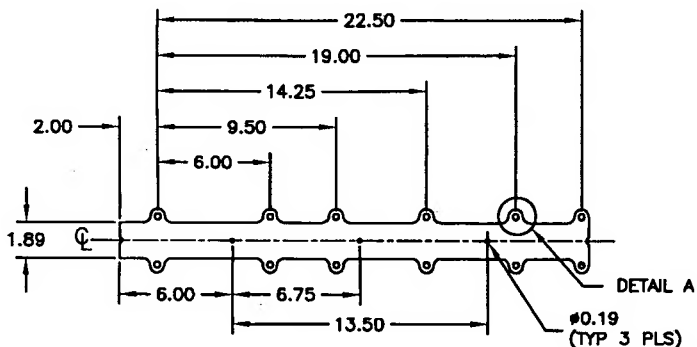
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

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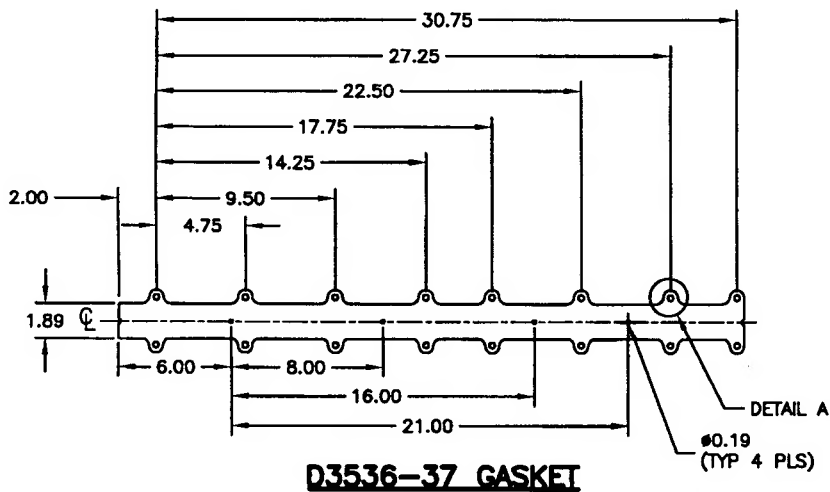
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			GASKET	SHEET 5 OF 6
				SCALE 1:10

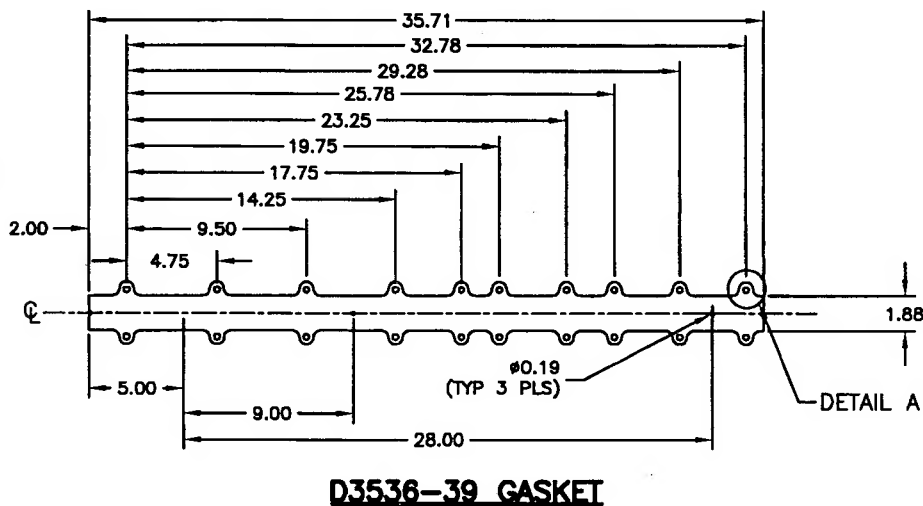
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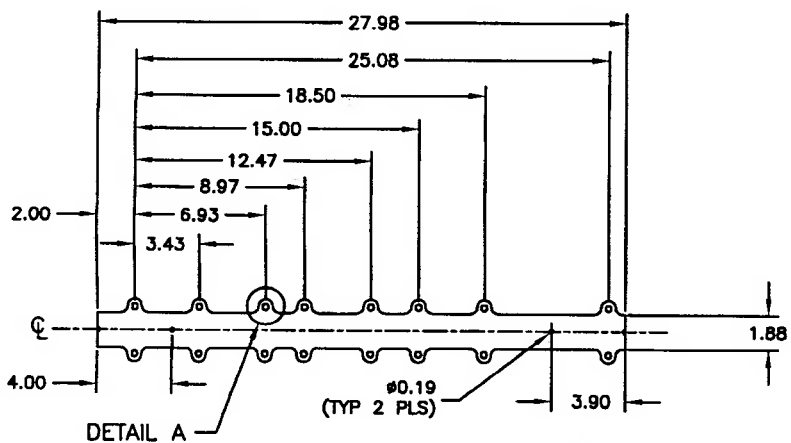
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- 2) FINISH: NONE
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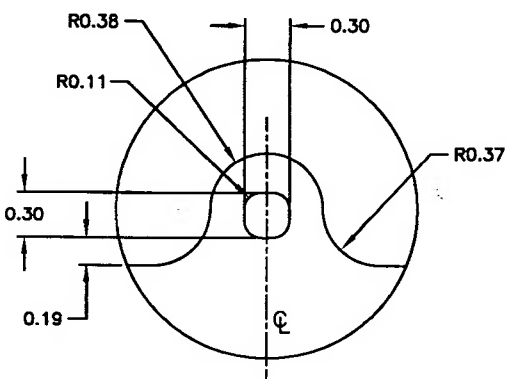
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DATE	06.10.25	TITLE	GASKET	REV. A	SHEET 6 OF 6
				SCALE	1:10

07.02.12 - 11



D3536-41 GASKET

DETAIL A



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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